

Date: Tuesday, 1/3/2006 4:18:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 0H-58 SKIDTUBE ASSEMBLY
Job Number	: 25368		
Estimate Number	: 10475		
P.O. Number	: N/A	Part Number	: D058672041
This Issue	: 1/3/2006	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2922 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A1
	Type : LANDING GEAR	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/30/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	1 Um: Each
Comment	: Est Rev:C 02.06.28 Re-format; ECN 258 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1	D2620	Bent Tube 3" OD	B24497 DP06-2-3 ①
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP06-2-3 ①

2-Cut aft end of D2620 bent tube as per dwg D2922

DP06-2-6 ①

3-Drill pilot holes using drill jig DT 8480 open to 0.312" dia.

DP06-2-6 ①

4-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

DP06-2-6 ①

5-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit

DP06-2-6 ①

~~6-Open CHW holes to 0.500 per dwg D2922~~

E

7-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922

DP06-2-6-①

8-Deburr and Blow out all chips form inside the tube

DP06-2-6 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-02-07 ①

4.0 D2923 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2923 Web

B25382

Pm 06-02-08 ①

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

Pm 06-02-08 ①

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

Pm 06-02-08 ①

3-Deburr and Blow out all chips from inside the tube

Pm 06-02-08 ①

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

Pm 06-02-08 ①

A/R Sikaflex-291

m19597

Sikaflex expire date: *06-06-18*

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 06-02-08

7.0 D2794 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description Batch
1 D2794 Fwd Cap

314400 BE 06-02-07 ①

8.0 D2649 Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number Description Batch
22 D2649 Crossbolt spacer

B24200 BE 06-02-07 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 25368

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

m15855 / m19100 BE 06-02-07 ①

2-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

m18839 BE 06-02-09 ①

3-Grind welds flush as per Dwg D2922

DP 06-2-10 ①

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

pm 06-02-15 ①

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Feb 17

PD 06-02-15

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G.M. 06-03-01

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 03 07

13.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch
5 D2648-3 Wearpad *024843*

FL

14.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe *021712*

FL

06 03 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25368

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-21 Wearshoe

Batch

B20532

FC

16.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2924 Wearshoe

Batch

B12425

FC

17.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 MS27039-1-08 Screw

Batch

m16941

FC

18.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 AN960JD10L Washer

Batch

m19185

FC

19.0

ALS41032130

Insert



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description

50 ALS4-1032-130 Insert

Batch

m18293

or (see QSI 017)

FC 06 03 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25368

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-1	Plugs	B2500

FC

21.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-3	O-Rings	B23941

FC

22.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B20208

FC

23.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-08	Screw	m169411

FC

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10L	Washer	m19185

FC 06 03 07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 25368

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates. FC

A/R Sikaflex-291

Sikaflex expire date: 06 18 06

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922 FC

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 06 18 06

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

M10037

FC 06 03 08 Batch:

26.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

CY 06/03/09

28.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/03/09

Job Completion



n 06/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	01.08.20	Ø0.640 WAS Ø0.625	

RELEASED
00.05.11 [Signature]

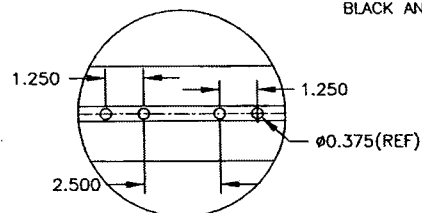
Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

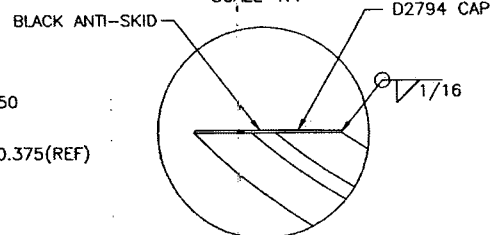
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4.
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF ROLLED COIL TUBE) AFTER FINISH (20 PLACES).

NOT FOR ROLLED COIL
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25368

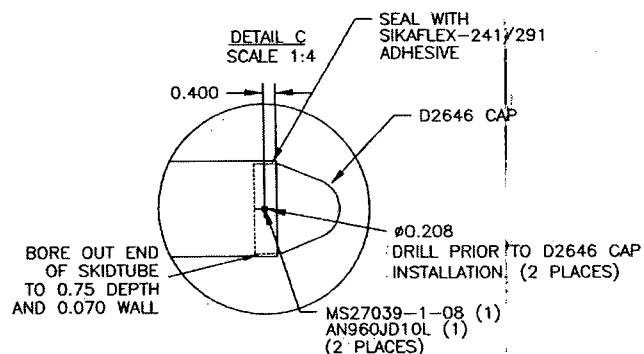
DETAIL A
SCALE 1:4



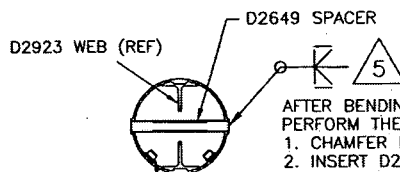
DETAIL B
SCALE 1:4



DETAIL C
SCALE 1:4



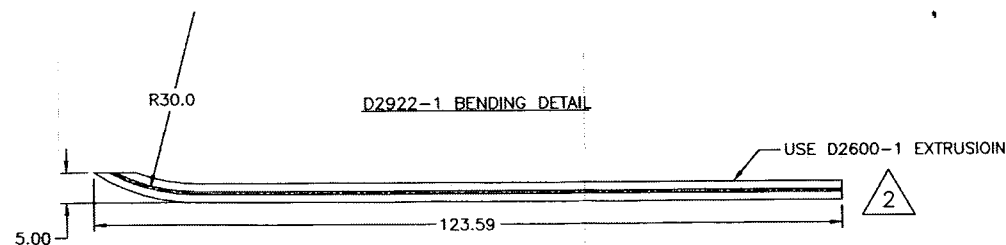
SECTION D-D
SCALE 1:4
FOR Ø0.375 HOLES ONLY



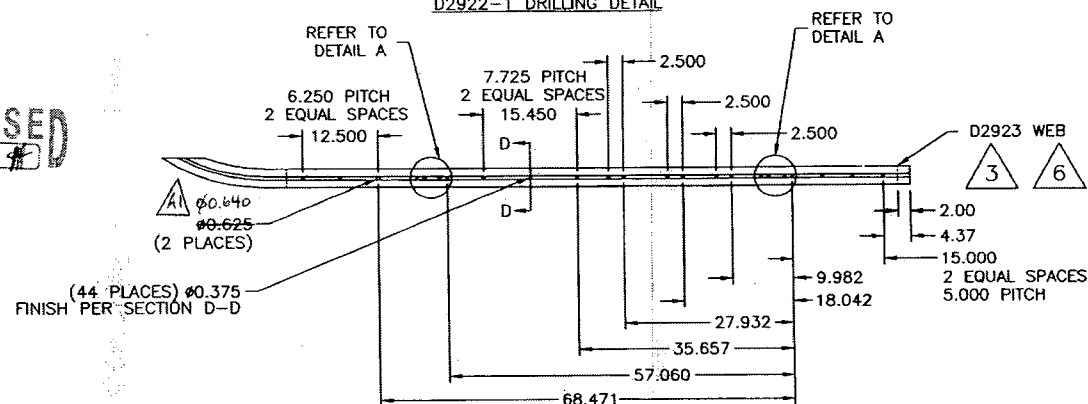
AKS7-1032-130 (REF)
(TYP. 50 PLACES)

RELEASED
00.05.11

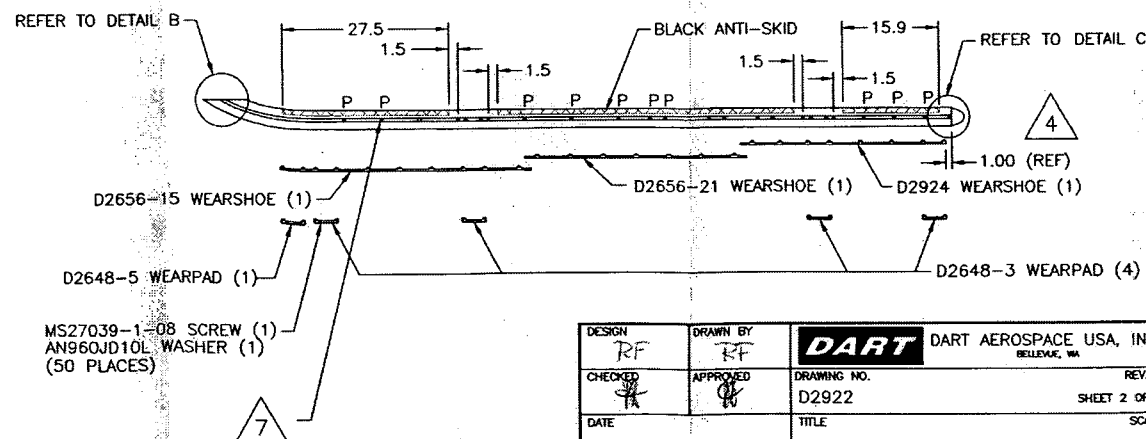
D2922-1 BENDING DETAIL



D2922-1 DRILLING DETAIL



D2922-041 ASSEMBLY DETAIL



DESIGN RF	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED TH	APPROVED W	DRAWING NO. D2922	REV. A SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE 1:20	

PK ORDER
25368
TO AMENDMENT
NOTICE
ROLLED COPY
NEERING
IN 17
CUT

